

5/20

DART AEROSPACE LTD	Work Order:	23135
Description: 206 A/B High Gear Web 05.01.13 EI 05.01.13	Part Number:	D2654-3
Drawing: D2654 Rev. DEO 9136	Qty:	2

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Issue Work Order	PH	05.04.29	2
2	METAL	Pick: Qty Part Number Description Batch 1 D2600-5 Web B124/33	DP	05/5/10	2
3	METAL	Cut D2600-5 to length as per Dwg D2654	DP	05.8-22	2
4	METAL	Drill pilot holes in web using drill jig DT 8018-3 as per Dwg D2654	PMC	05.8-29	2
5	METAL	Using the uni-bit, open holes to finish size as per Dwg D2654	PMC	05.8-29	2
6	METAL	Deburr holes and ends	PMC	05.8-29	2
7	METAL	Acid Etch and Alodine as per QSI 005 4.1	PMC	05.8-30	2
8	QC	Inspect Level 5	Z	05.06.30	2
9	METAL	Identify and stock	PMC	05.9-7	2
10	EXPEDITING	Close Work Order Inspect level 21 Cost/part: 33.61 545 05/09/08 (2) 05/09/08 2 41.69			

Rev	Date	Change	Revised By	Approved
A	97.07.30	New Issue	JB	
B	97.08.28	Change part No. Step 1 & 2	KS	
C	98.09.14	Re-format, drawing rev.	CS	
D	99.02.04	Fixed typo, Changed procedure	DM	02/05/11

RELEASED

02/05/11

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes No DQA: 

Date: 05/09/08

NOTE: Date & initial all entries

QA: N/C Closed: _____

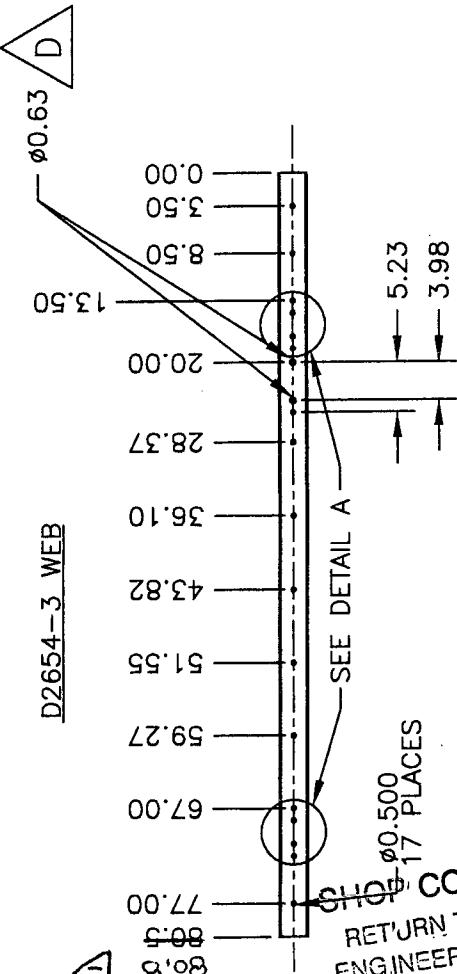
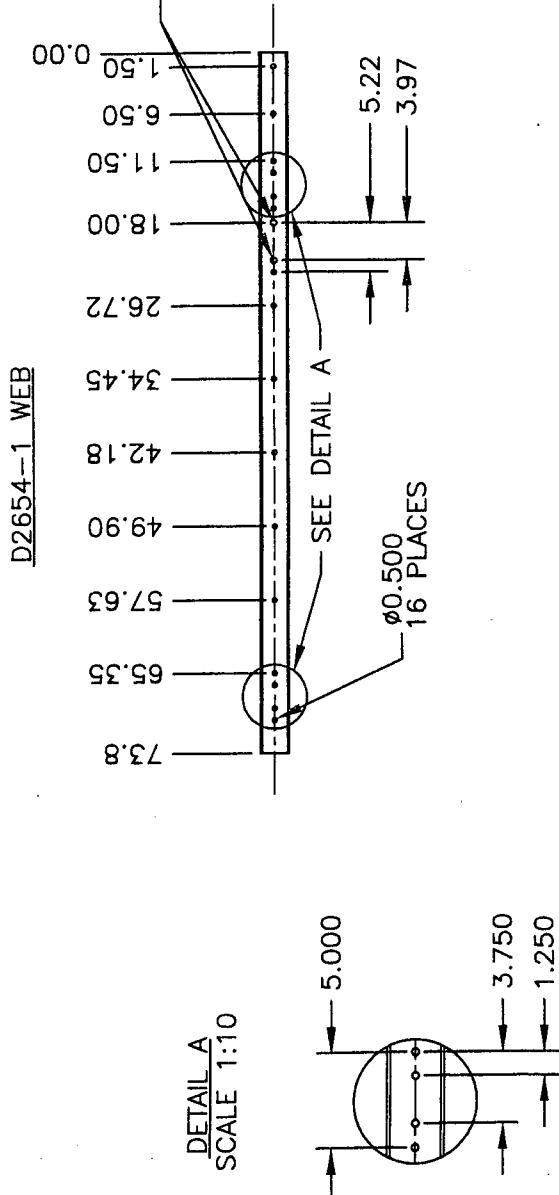
Date: _____

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DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D2654
DATE		REV. E SHEET 1 OF 2
04.05.26		SCALE 1:20
A	97.03.25	NEW ISSUE
B	97.06.26	ALTER HOLE PATRN., 0.500 WAS 0.438
C	97.10.29	CHANGED HOLE PATTERN
D	98.01.15	GHW HOLES CHANGED TO Ø0.63
E	04.05.26	CHANGE LENGTHS, REFORMAT
E1	04.08.04	PER TOOLING; 80.8 WAS 80.5

RELEASED
04.06.22

D



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WITHOUT NOTICE
WORK ORDER
NO. 23135

MAKE FROM D2600-5-108 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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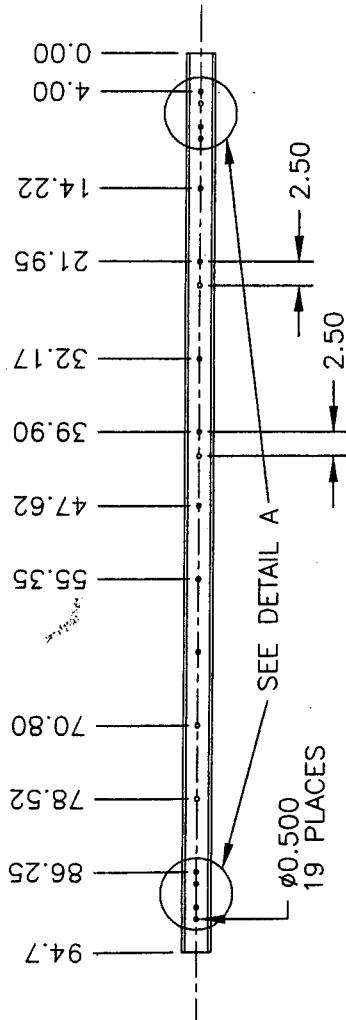
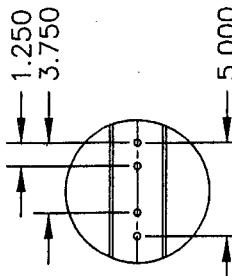
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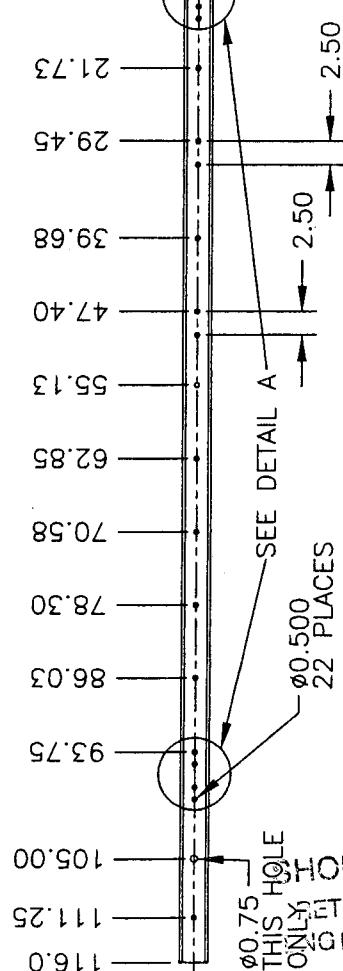
DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
4P	4P	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. E
		D2654	SHEET 2 OF 2
DATE		TITLE	SCALE
04.05.26		WEB	1:20

RELEASED
04.05.26

D2654-5 WEB

DETAIL A
SCALE 1:10

D2654-7 WEB



MAKE FROM D2600-7-125 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WORK ORDER
NO. 23135

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DESIGN DS	DRAWN BY DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED DM	APPROVED KE	DRAWING NO. DEO 9136
DATE 99.02.26		TITLE 206 SKIDTUBE WEB LENGTH CHANGE NTS
A	99.02.26	SCALE NEW ISSUE

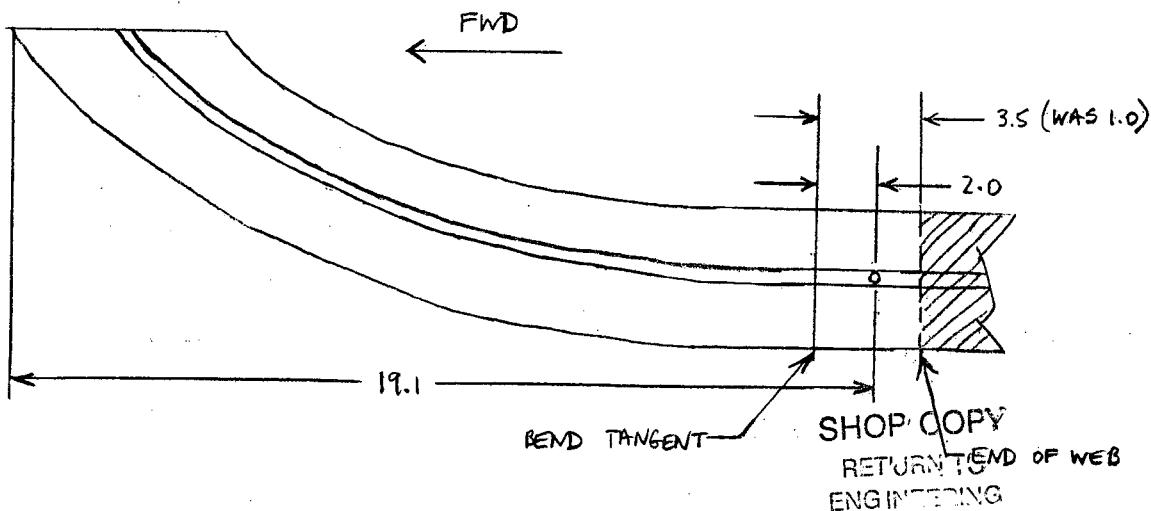
DART ENGINEERING ORDER

TO AMEND DWGS : D2650 REV. C
D2654 REV. D

TO FACILITATE BENDING D206-642 SKIDTUBES IN-HOUSE, ALL WEBS CALLED UP ON DWG D2654 SHOULD BE SHORTENED BY 2.50" AT THE FWD END. THIS WILL ELIMINATE THE NEED TO DRILL THE FWD HOLE ON ALL WEBS SHOWN ON DWG D2654. THE REVISED LENGTHS ARE AS FOLLOWS:

PART NO.	LENGTH WAS	LENGTH NOW
D2654-1	76.35	73.85
D2654-3	83.35	80.85
D2654-5	91.25	94.75
D2654-7	118.50	116.00

THE BENDING DETAIL ON PAGE 7 OF DWG. D2650 WILL NOW BE AS FOLLOWS:



IT IS ACCEPTABLE TO ENGINEERING TO HAVE A MAXIMUM REDUCTION IN DIAMETER OF 0.150" FWD OF THE WEB IN THE BENT PORTION OF THE TUBE. EJECT 1.0" FROM BEND WITHOUT NOTICE

RELEASED
99.03.02 DS

WORK ORDER
NO. 23135

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Apr 29, 2005
11:31 am

Work Order No : 0023135
 Project Name : D2654-3
 Project For : WK520
 Work Order Type : Main
 Main WO Number :
 House Part Number : D2654-3
 Description : 206 I-Beam (Web)
 Manufactured : Yes
 Amount Req'd : 2
 Amount Done : 0
 Start Date : 04-29-05
 Est Finish Date : 05-15-05
 Act Finish Date :
 Drawings Reqd : No
 Ok for Approval :
 Approval Rec'd : \$0 Posted to Finished Goods

Department Code:
 Burden Flags : NNNNNNN
 WO Status : Open
 Invoice State : Not Invoiced
 Invoice Date :
 Invoice Number :
 Invoice Amount : 0.00

Order Entry No :
 OE Value : 0.00

Est Mark Up : 0.000%
 Actual Mark Up : 0.000%

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
===== ===== =====					
Burden	0.00	0.00	0.00		
===== ===== =====					
Total Cost	0.00	0.00	0.00		
Mark up	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00